

5-6. Wire Material, Wire Type, And Gas Selection Table

Wire Material	Program No.	Wire Type	Wire Diameter mm (in)	Gas Type					MIG Process	
				CO2 100%	Ar80/CO 2	Ar98/CO 2	Ar98/O2	Ar100	Pulsed	Standard
Carbon Steel	1003	AWS	0.8 (0.030)		X				X	
	1004		1.0 (0.035)		X				X	
	1005		1.2 (0.045)		X				X	
	1013		0.8 (0.030)		X					X
	1014		1.0 (0.035)		X					X
	1015		1.2 (0.045)		X					X
	1050	AWS	0.8 (0.030)	X						X
	1051		1.0 (0.035)	X						X
	1052		1.2 (0.045)	X						X
Stainless Steel	3000	308L	0.8 (0.030)			X			X	
	3001		1.0 (0.035)			X			X	
	3002		1.2 (0.045)			X			X	
	3010		0.8 (0.030)			X				X
	3011		1.0 (0.035)			X				X
	3012		1.2 (0.045)			X				X
	3101		1.0 (0.035)			X			X	
	3102		1.2 (0.045)			X			X	
	3111		1.0 (0.035)			X				X
	3112		1.2 (0.045)			X				X
	3020	309L	0.8 (0.030)			X			X	
	3021		1.0 (0.035)			X			X	
	3022		1.2 (0.045)			X			X	
	3030		0.8 (0.030)			X				X
	3031		1.0 (0.035)			X				X
	3032		1.2 (0.045)			X				X
	3121		1.0 (0.035)			X			X	
	3122		1.2 (0.045)			X			X	
	3131		1.0 (0.035)			X				X
	3132		1.2 (0.045)			X				X
Stainless Steel	3040	316L	0.8 (0.030)			X			X	
	3041		1.0 (0.035)			X			X	
	3042		1.2 (0.045)			X			X	
	3050		0.8 (0.030)			X				X
	3051		1.0 (0.035)			X				X
	3052		1.2 (0.045)			X				X
	3141		1.0 (0.035)			X			X	
	3142		1.2 (0.045)			X			X	
	3151		1.0 (0.035)			X				X
	3152		1.2 (0.045)			X				X

			Wire Di- ameter	Gas Type				MIG Process			
Stainless Steel	3060	2209	1.0 (0.035)			X			X		
	3061		1.2 (0.045)			X			X		
	3070		1.0 (0.035)			X				X	
	3071		1.2 (0.045)			X				X	
	3062	2507	1.0 (0.035)			X			X		
	3063		1.2 (0.045)			X			X		
	3072		1.0 (0.035)			X				X	
	3073		1.2 (0.045)			X				X	
Aluminum	5000	AlSi5	1.0 (0.035)					X	X		
	5001		1.2 (0.045)					X	X		
	5002		1.6 (0,062)					X	X		
	5010		1.0 (0.035)					X		X	
	5011		1.2 (0.045)					X		X	
	5012		1.6 (0,062)					X		X	
	5020	AlMg5	1.0 (0.035)					X	X		
	5021		1.2 (0.045)					X	X		
	5022		1.6 (0,062)					X	X		
	5030		1.0 (0.035)					X		X	
	5031		1.2 (0.045)					X		X	
	5032		1.6 (0,062)					X		X	
	5040	Al 99	1.0 (0.035)					X	X		
	5041		1.2 (0.045)					X	X		
	5042		1.6 (0,062)					X	X		
	5050		1.0 (0.035)					X		X	
	5051		1.2 (0.045)					X		X	
	5052		1.6 (0,062)					X		X	
	Special Materials	7000	MCWF	1.0 (0.035)		X				X	
		7001		1.2 (0.045)		X				X	
7002		1.6 (0,062)			X				X		
7010		1.0 (0.035)			X					X	
7011		1.2 (0.045)			X					X	
7012		1.6 (0,062)			X					X	
7080		CuAl8	1.2 (0.045)					X	X		
7090			1.2 (0.045)					X		X	
7100		CuSi3	1.2 (0.045)					X	X		
7110			1.2 (0.045)					X		X	
Special Materials	7120	CuSn6	1.0 (0.035)					X	X		
	7130		1.0 (0.035)					X		X	
Special Materials	7140	N 625	1.0 (0.040)					X	X		
	7141		1.2 (0.045)					X	X		
	7150		1.0 (0.040)					X		X	
	7151		1.2 (0.045)					X		X	

Special Materials		Wire Di- ameter	Gas Type				MIG Process			
	7160	CoCr	1.2 (0.045)					X	X	
	7180		1.6 (0.063)					X		X
	7030	FCWR	1.2 (0.045)		X					X
	7050	FCWB	1.2 (0.045)		X					X
	7070	FCSS	1.2 (0.045)		X					X